

Work Order ID 92120 - 2

Tuesday, October 23, 2012 4:11:59 PM

92120

Page 1

Item ID: PB67-43001-11

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Fwf Adjustable Blade Support Assembly

Stop *NS2*

Start Date: 10/23/2012 Start Qty: 4.00 *4*

Required Date: 11/2/2012 Req'd Qty: 4.00 *4*

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: MLS

Date: 12-10-25 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept
Qty Reject
Qty Reject
Number Insp.
Stamp

Draw Nbr

Revision Nbr

B67-43001-11

Rev C

100

0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

1- make a 0.090" chamfer in the 1.00" hole before welding

2- assemble parts and weld as per dwg

3- grind weld flush in area of PB67-43001-249 only

4- install helicol insert as per dwg

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Memo

0.00

Quality Control

(1x)

cc 12-12-4

11 12-22-05

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Cust Item ID:

Required Date: 11/2/2012 Req'd Qty: 4.00 ***4***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

160

Green Sandtex(Ref:4.3.5.8) per QSI005 4.3

0.00

160

Powdercoat

Memo

0.00

Powder Coating

1- MASK TUBE FROM BASE TO GUSSET START TIME:
2:45 OVEN TEMPERATURE: 320°F FINISH
TIME: 3:15

M14144

4 11/12/12 5
4X
M
12/12/10

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Item ID: PB67-43001-11

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Setup Start

NS1

Revision ID:

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NS2

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Start Date: 10/23/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 11/2/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC3- Inspect Part Finish

0.00

170

QC

Memo

0.00

Quality Control

4 12/12/10

180

Small Fab

0.00

180

Small Fab

Memo

0.00

Small Fab

1- match drill cover to existing holes in support2- assemble as per dwg

113 13

DAS 19
12/12/10

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

DAS 16
12/12/10DAS 16
12/12/10

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Revision ID:

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Cust Item ID:

Required Date: 11/2/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

Identify as per dwg & Stock Location: 11.11.11

0.00

200

Packaging

Memo

0.00

Packaging

210

QC21- Final Inspection - Work Order Release

0.00



210

QC

Memo

0.00

Quality Control

13/1/10 
WF 13-01-09 
12-12-19

Picklist Print

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Page 1

Work Order ID: 92120

Parent Item: PB67-43001-11

Parent Item Name: Fwf Adjustable Blade Support Assembly

Start Date: 10/23/2012

Required Date: 11/2/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-06-26 new issue DD verified by:ec
dwg EC verified by:DD IPP Rev B 10.09.27 per revC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
PB67-43001-67 PB67-43001-67		Manufactured	No		B93495 = 4		Each	1.0000		4		11-12-11-30	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				WA		1							
					85187	1							
PB67-43001-247 Inner Tube		Manufactured	No		B90926 (4)	100	Each	0.0000	1	4		11-12-11-30	
PB67-43001-249 Inner Tube Bushing		Manufactured	No			100	Each	3.0000	1	4		11-12-11-30	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST438	B90927	3							
					52480	3							
PB67-43001-253 Gusset		Manufactured	No			100	Each	7.0000	1	4		11-12-11-30	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				WA		7							
					85185	7							
PB67-43001-254 Gusset		Manufactured	No			100	Each	16.0000	1	4		11-12-11-30	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST438		16							
					52481	16							
MS124780 HELICAL INSERT		Purchased	No			180	Each	82.0000	1	4		11-12-11-30	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST333		82							
					111064	82							

Picklist Print

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Work Order ID: 92120

Parent Item: PB67-43001-11

Parent Item Name: Fwf Adjustable Blade Support Assembly

Start Date: 10/23/2012

Required Date: 11/2/2012

Start Qty: 4.00

Required Qty: 4.00

MS27039-1-10 Purchased No

180 Each 416.0000 8 32

Screw

Location	Loc Qty	Loc Code
308 12345	8	
122441	8	
GA	100	
120449	100	
ST291	5	
120120	5	
ST305	300	
122815	300	
ST308	3	
122027	3	

12.8

NAS1149D0316J Purchased No

180 Each 400.0000 8 32

Washer

Location	Loc Qty	Loc Code
ST298	400	
122151	400	

12.8

NAS1149D0363J Purchased No

180 Each 4.785.0000 8 32

Washer

Location	Loc Qty	Loc Code
ST294	1854	
123248	1254	
123355	600	
ST297	2820	
122378	2820	
ST298	111	
117601	61	
119537	33	
120308	17	

12.8

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Shop Packet Print

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Picklist Print

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Work Order ID: 92120

Parent Item: PB67-43001-11

Parent Item Name: Fwf Adjustable Blade Support Assembly

Start Date: 10/23/2012

Required Date: 11/2/2012

Start Qty: 4.00

Required Qty: 4.00

PB67-43001-69
90 Degree Cover Plate

Manufactured No

180

Each

1.0000

1

4

Location

ST437A

52433

Loc Qty

1

1

Loc Code

3X

~~10/23/12~~
11/3/12

PB67-43001-83

PB67-43001-83

Manufactured No

180

Each

5.0000

1

4

Location

ST444

53240

Loc Qty

5

5

Loc Code

3X

~~10/23/12~~
11/3/12

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Shop Packet Print

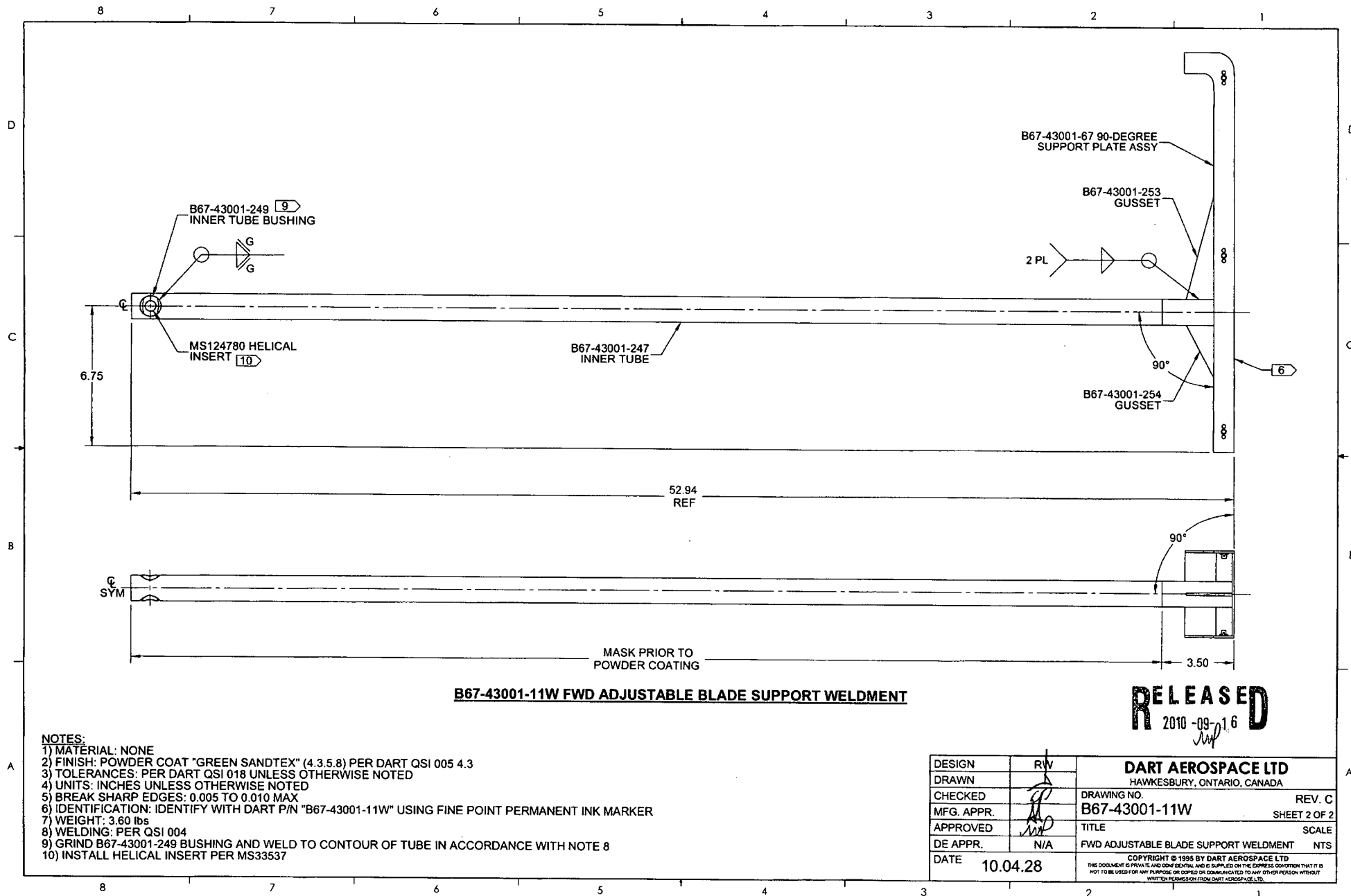
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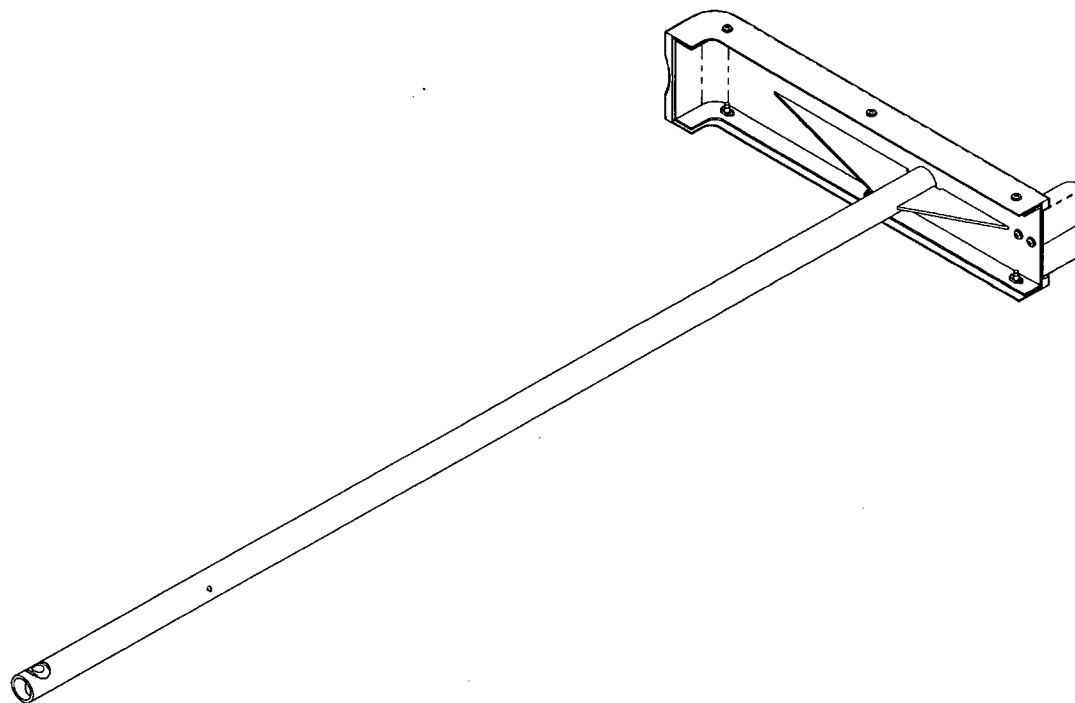
B67-43001-11W FWD ADJUSTABLE BLADE SUPPORT WELDMENT

ITEM	QTY -11W	P/N	DESCRIPTION
1	X	B67-43001-11W	FWD ADJUSTABLE BLADE SUPPORT WELDMENT
2	1	B67-43001-67	90-DEGREE BLADE SUPPORT ASSY
3	1	B67-43001-247	INNER TUBE
4	1	B67-43001-253	GUSSET
5	1	B67-43001-254	GUSSET
6	1	B67-43001-249	INNER TUBE BUSHING
7	1	MS124780	HELICAL INSERT

RELEASED
2010-09-18

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 8 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	10.04.28
REV.	DESCRIPTION		BY	DATE
DESIGN	R/W	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. B67-43001-11W TITLE FWD ADJUSTABLE BLADE SUPPORT WELDMENT SCALE NTS DATE 10.04.28 <small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.	N/A	REV. C SHEET 1 OF 2		





B67-43001-11 FWD ADJUSTABLE BLADE SUPPORT ASSY

ITEM	QTY -11	P/N	DESCRIPTION
1	X	B67-43001-11	FWD ADJUSTABLE BLADE SUPPORT ASSEMBLY
2	1	B67-43001-11W	FWD ADJUSTABLE BLADE SUPPORT WELDMENT
3	1	B67-43001-69	90° COVER PLATE ASSEMBLY
4	1	B67-43001-83	SHORT D-PAD ASSY
5	8	MS27039-1-10	SCREW
6	8	NAS1149D0316J	WASHER
7	6	NAS1149D0363J	WASHER

RELEASED
2010-09-16
MM

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DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. B67-43001-11 TITLE FWD ADJUSTABLE BLADE SUPPORT ASSY DATE 10.04.28		
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.	N/A	REV. C SHEET 1 OF 2 SCALE NTS		
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